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DAS
21
9-89

D4436-045
Job Sheet 196411



Part No: D4436-045

Job Qty: 8 pcs

Part Name: Aft Inboard Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/12/19

Job Tracking No:

Due Date: 7/8/19

Created By: Lorin Baltac

Type: SOLD

Description:

Note: D4436 REV.B IPP revA 11.10.06 new issue EC verified by:DD IPP RevB 11.12.22 per PA2 EC verified by:JLM
IPP REV:C 12.01.24 PER DWG REV.A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8		7/8/19	0.17	1.43	Waterjet - Flow		
		pcs							
110	QC 2	8		7/8/19	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S212661

Part: D4436-045

Job No: 196411

Serial No/Batch: S212661

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/11/19

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120 QC 8	8 pcs	7/8/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRP 9/11/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS 40 SEP 12 2019 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	DAS 58 SEP 12 2019 9-89
125 Small Fab - 2 - B4B	8 pcs	7/8/19	0.00 1.56	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
130 Small Fab - Brake NC - B4B	8 pcs	7/8/19	0.25 1.10	Small Fab - Brake - 1 - B4B	DAS 30 OCT 03 2019 9-89
				Small Fab - Brake - 2 - B4B	
				Small Fab - Brake - 3 - B4B	
150 QC 5	8 pcs	7/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40 OCT 07 2019 9-89

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160 Handfinish - 1-1 Chemical-B4B	8 pcs	7/8/19	0.00 0.69	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
170 QC 7	8 pcs	7/8/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
180 Small Fab - 2 - B4B	8 pcs	7/8/19	0.00 1.56	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
185 QC 5	8 pcs	7/8/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	

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					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
190 Powdercoat - 4 Black Sand - B4B	8 pcs	7/8/19	0.00 0.40		Powdercoat - 1 - B4B	OCT 09 2019
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
200 QC 3	8 pcs	7/8/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
202 Small Fab - 2 - B4B	8 pcs	7/8/19	0.00 1.56		Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
205 QC 5	8 pcs	7/8/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	

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210 Packaging 3-1 - Stock - B4B	8 pcs	7/8/19	0.00 0.00	QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	8 pcs	7/8/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

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Part Op 100 - 1-Cut D4436-3 as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

125 - 1- Transfer drill holes as per dwg. 2-C"SINK AS PER DWG 3-TRANSFER 0.129 HOLES THRU (2 PLACES)

130 - (Bend/Assemble as per dwg)

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Chemical Conversion Coat per QSI005 4.1)

170 - (QC7-Inspect Chemical Conversion Coat)

180 - Assemble as per dwg, do not install grommets and rubber seal.

185 - (QC5- Inspect part completeness to step on W/O)

190 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

200 - (QC8- Inspect parts - second check)

202 - Cut qty 1 to 3.8" Cut qty 1 to 10.00" Install rubber seals and grommets, as per dwg

205 - (QC5- Inspect part completeness to step on W/O)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	5,5120 sf (.689 ea)	100-Waterjet - Flow - 1	5204169
MS20426AD3-2	Rivet	32 Ea (4 ea)	180-Small Fab - 2 - B4B	3174201
MS20470AD4-3	Rivet, Universal Head	16 Ea (2 ea)	180-Small Fab - 2 - B4B	3080639
MS21075L08	Anchor Nut	16 Ea (2 ea)	180-Small Fab - 2 - B4B	3156774
D4441-1	Rubber Seal	9,2000 ft (1.15 ea)	202-Small Fab - 2 - B4B	5092167
MS35489-19	Grommet	8 Ea (1 ea)	202-Small Fab - 2 - B4B	3067899

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.040 DAS	6	320	0
180-Small Fab - 2 - B4B	MS20426AD3-2 30	32	18,520	0
	MS20470AD4-3 9-89	16	4,116	0
	MS21075L08	16	185	0
202-Small Fab - 2 - B4B	D4441-1	9	341	0
	MS35489-19	8	58	0

Part Specifications

Specifications could not be found.

Plex 6/12/19 1:52 PM Dart.Baltac.Lorin

